

Work Order ID 63286

Wednesday, October 27, 2010 10:17:14 AM

Page 1

Item ID: D212-725-1-215F

Accept

Setup Start

Revision ID:

Stop

Item Name: Shield Tail Pipe

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

E

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

B10-10-28



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63286

Page 2

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Start Date: 10/27/2010 Start Qty: 2.00



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Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo ***FLAT PATTERN ONLY***	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

S 10/10/29

④

C. 10/10/29 ①

10/10/29

WVF
10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 10:17:18 AM

Page 1

Work Order ID: 63286



Parent Item: D212-725-1-215F



Parent Item Name: Shield Tail Pipe

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.07.21 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S25GA

Purchased

No

100

sf

19.1900

4.95

10.42105



1810-10-28

304/316 .020" Sheet

Location

Loc Qty

Loc Code

MAT20

19.19

107436

16.19

107513

3

107513



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NOTE: Date & initial all entries

4516-705-1-215F

X	First Article	X	Prototype
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Measured by: RB	Audited by: S	Prototype Approval:
Date: 10-10-29	Date: 10/10/29	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revD

SHO.

RETURN

ENGINEERING

UNCONTROLLED COPY

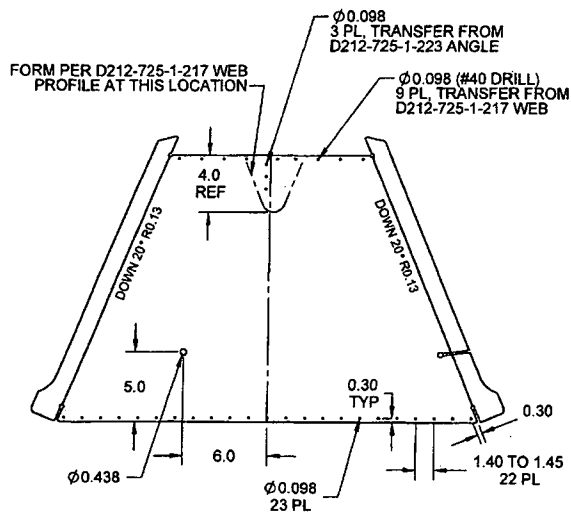
SUBJECT TO AMENDMENT

WITHOUT NOTICE

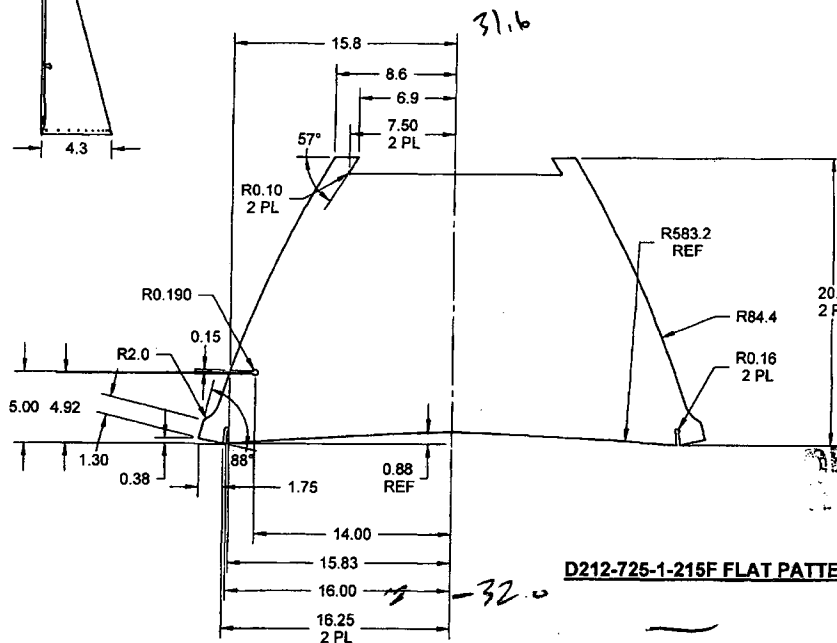
WORK ORDER

NO. *63284*

10-10-27





D212-725-1-215 SHIELD TAIL PIPE
(MAKE FROM D212-725-1-215F FLAT PATTERN)



RELEASED
2009-10-28

NOTES:

- 1) MATERIAL: AISI 304/316/321 ANN STAINLESS STEEL 0.020 (25 GAUGE) SHEET PER AMS-5513/5524/5510
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV.
MFG. APPR.	N/A	D212-725-1	SHEET 75 OF 82
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	08.09.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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